

Date
UserTuesday, 10/23/2007 3:11:18 PM
Kim Johnston

Process Sheet

split w/ 8B 07/11/11

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ASPIRATOR ASSEMBLY

Job Number : 35329 -2 Part Number : D2410

Estimate Number : 10480 Drawing Number : D2410

P.O. Number : N/A Project Number : N/A

This Issue : 10/23/2007 S.O. No. : N/A Drawing Revision : A1

Prsht Rev. : NC Material : N/A

First Issue : N/A Type : SMALL /MED FAB Due Date : 11/10/2007 Qty: 4 Um: Each

Previous Run : 26895

Written By : 10/07/10 23

Checked & Approved By : 10/07/10 23

Comment : Est:C 09/04/14 Reformat; Incorporated D2292;
D2375-3-08-106; D2403 - D2417 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2375308 Insulation 48'of 3"ID*1/



Comment: Qty.: 0.8333 f(s)/Unit Total : 3.3332 f(s)
Insulation 48'of 3"ID*1/

Pick:

Qty	Part Number	Description	Batch
10.6"	D2375-3-08	Insulation	M1810

FF 07-11-15

(4)

2.0 D2403 Outer Skin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Outer Skin

Pick:

Qty	Part Number	Description	Batch
1	D2403	Outer Skin	B35333

35015 FF 07-11-15

(4)

3.0 D2404 Perforate Sheet,0.125 Ho



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Perforate Sheet,0.125 Ho

Pick:

Qty	Part Number	Description	Batch
1	D2404	Perforated Sheet	B35334

35015 FF 07-11-15

(4)

4.0 D2411 Valve support, 5052-H34



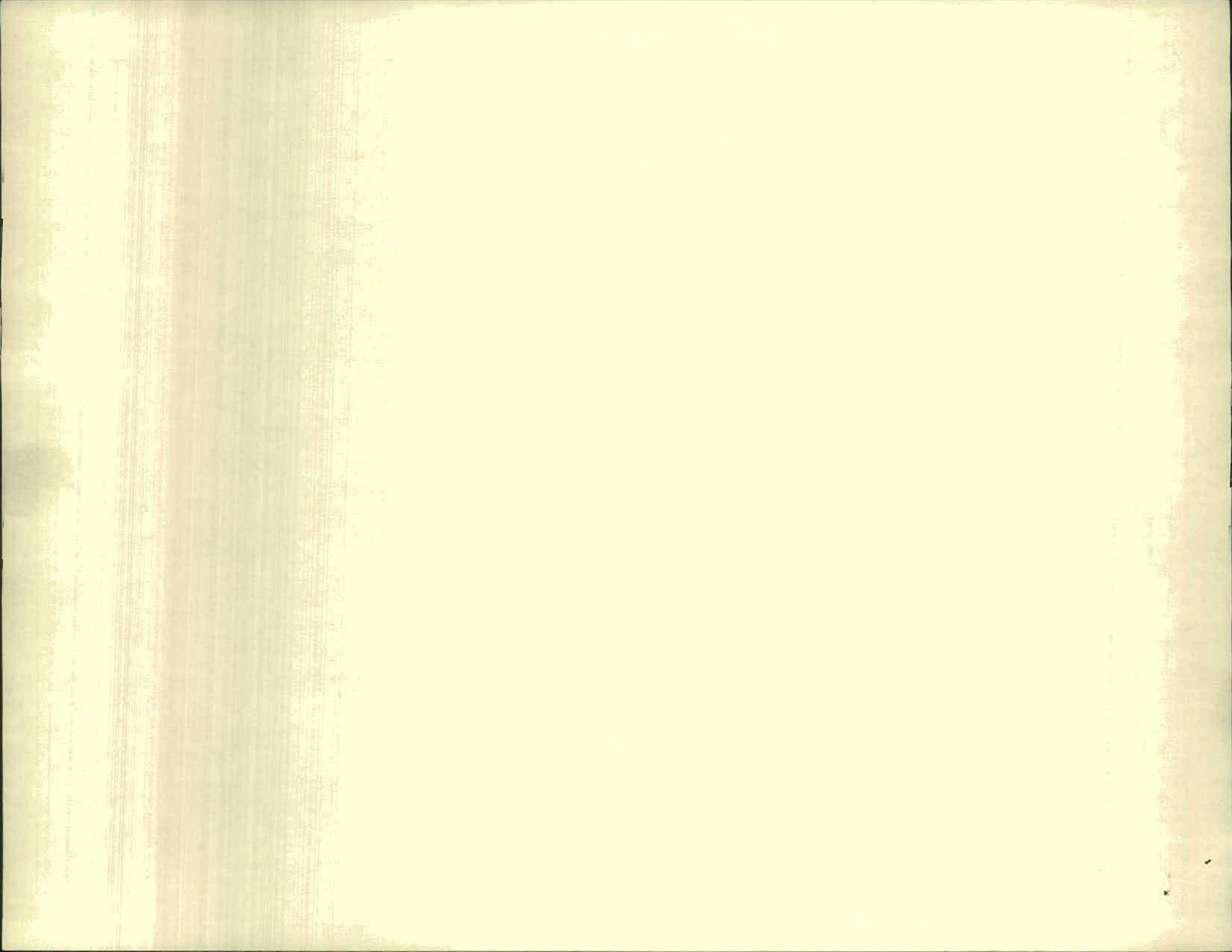
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Valve support, 5052-H34

Pick:

Qty	Part Number	Description	Batch
1	D2411	Valve Mtg Angle	M24398

M24398 FF 07-11-15

(4)



Process Sheet

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Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 35329

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2412

Insulation filter



Comment: Qty.: 0.7673 sf(s)/Unit Total: 3.0692 sf(s)

Insulation filter

Pick:

Qty

Part Number

Description

Batch

110.5si

D2412

Insulation Filter

B31028

FF 07-11-19

6.0

D2413

Intake Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Intake Weldment

Pick:

Qty

Part Number

Description

Batch

1

D2413

Intake Assembly

35335

FF 07-11-16

7.0

D2414

Outlet Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Outlet Weldment

Pick:

Qty

Part Number

Description

Batch

1

D2414

Outlet Assembly

35336

35336

8.0

D2416

Mounting angle, 1x.625x



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty

Part Number

Description

Batch

1

D2416

Mounting Angle

35960

35960

FF 07-11-29

9.0

D2417

Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty

Part Number

Description

Batch

1

D2417

Mounting Angle

35960

35960

FF 07-11-20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 35329

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total: ~~32.0000~~ Each(s)

Rivet, Universal Head

Pick:

Qty

Part Number

Description

Batch

8

MS20470AD4-5

Rivet

1041304

SD

11.0

MS20600AD4W2

Rivet



Comment: Qty.: ~~8.0000~~ Each(s)/Unit Total: ~~32.0000~~ Each(s)

Rivet

Pick:

Qty

Part Number

Description

Batch

8

MS20600AD4W2

Rivet

144747

SD

(P12) →

(or CR9163-4-2)

12.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Cherry Rivets

Pick:

Qty

Part Number

Description

Batch

10

MS20600AD4W3

Rivet

141500

SD

(or CR9163-4-3)

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Rivets

Pick:

Qty

Part Number

Description

Batch

2

MS20600AD4W4

Rivet

14105792

14105783

7-11-1550

(4)

(or CR9163-4-4)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2410

FF

07-12-13

(P10) →

(1)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 35329

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/13 (X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3,5.1) as per QSI 005 4.3

****Place masking tape on red anodize tube of flare section and access to interior of both ends.****

M 105914
M 105914 m-k 07/12/17 (1)
07-12-13

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-12-13 (X)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07-12-18 (1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/20 (1)

Job Completion



2007/12/19 CZ

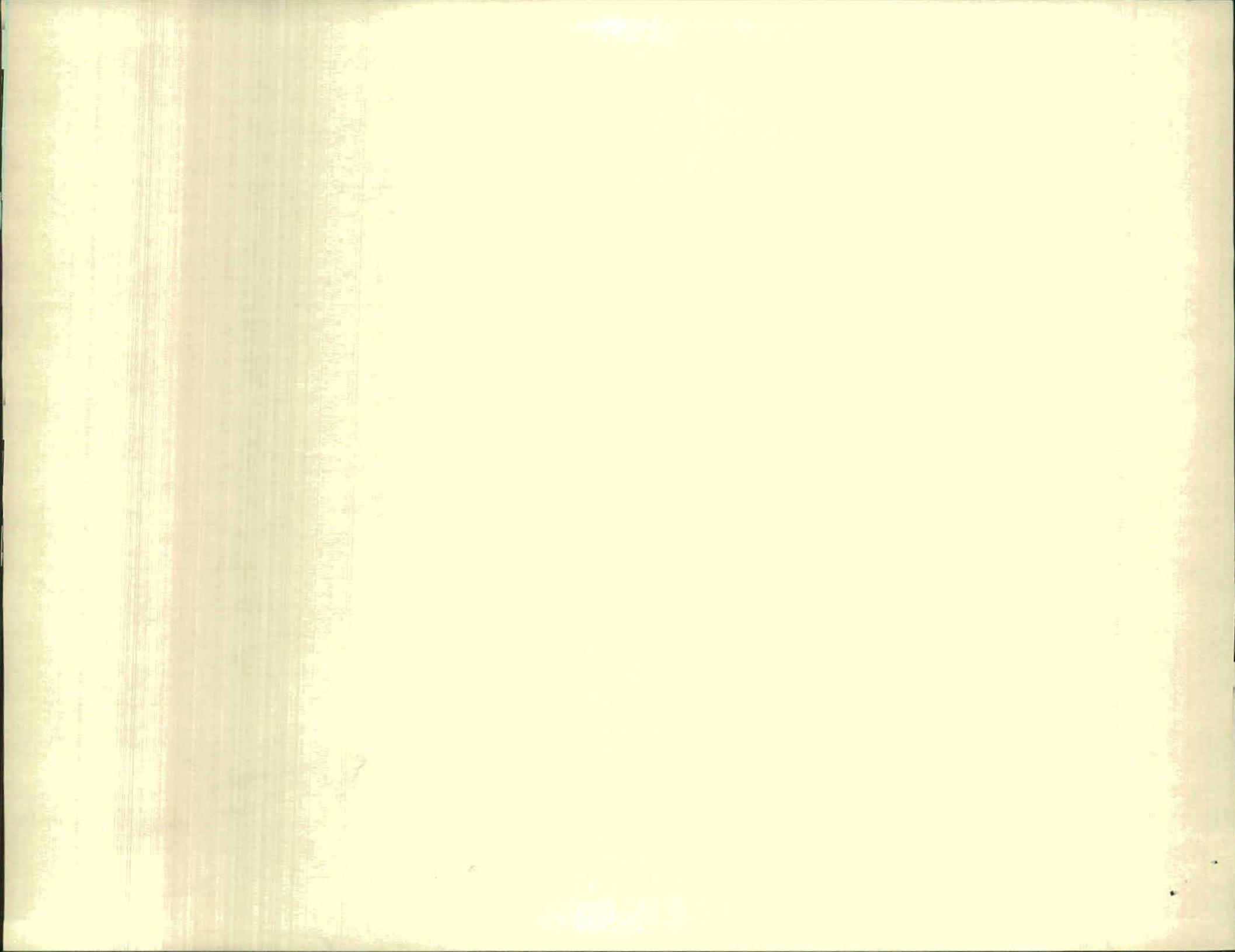
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/21	12.0	3 parts, the slams kept pulling out of the mat. upon chiselling out the mat, the hole slightly oversized.	ES/16/2	Use CR 3.013-4005 on 14471 insert in a 3rd hole. Acceptable.	FF 07/11/21	07/11/21	ES/16/2	07/11/21
07/11/27	14	Slam pulled out during Rindrig. Hamm error	UE 07.12.04	Change to CR 3.013-4005 CR 3.013-5-3 (Drill to suit 1/16") drill to fit track.	FF 07/11/21		UE 07.12.04	07/11/27
		Change Quantities as indicated	ES/16/2	MS20000 AD4W3-14 MS20000 AD4W4-2 Permanent Change	FF 07/11/21		ES/16/2	

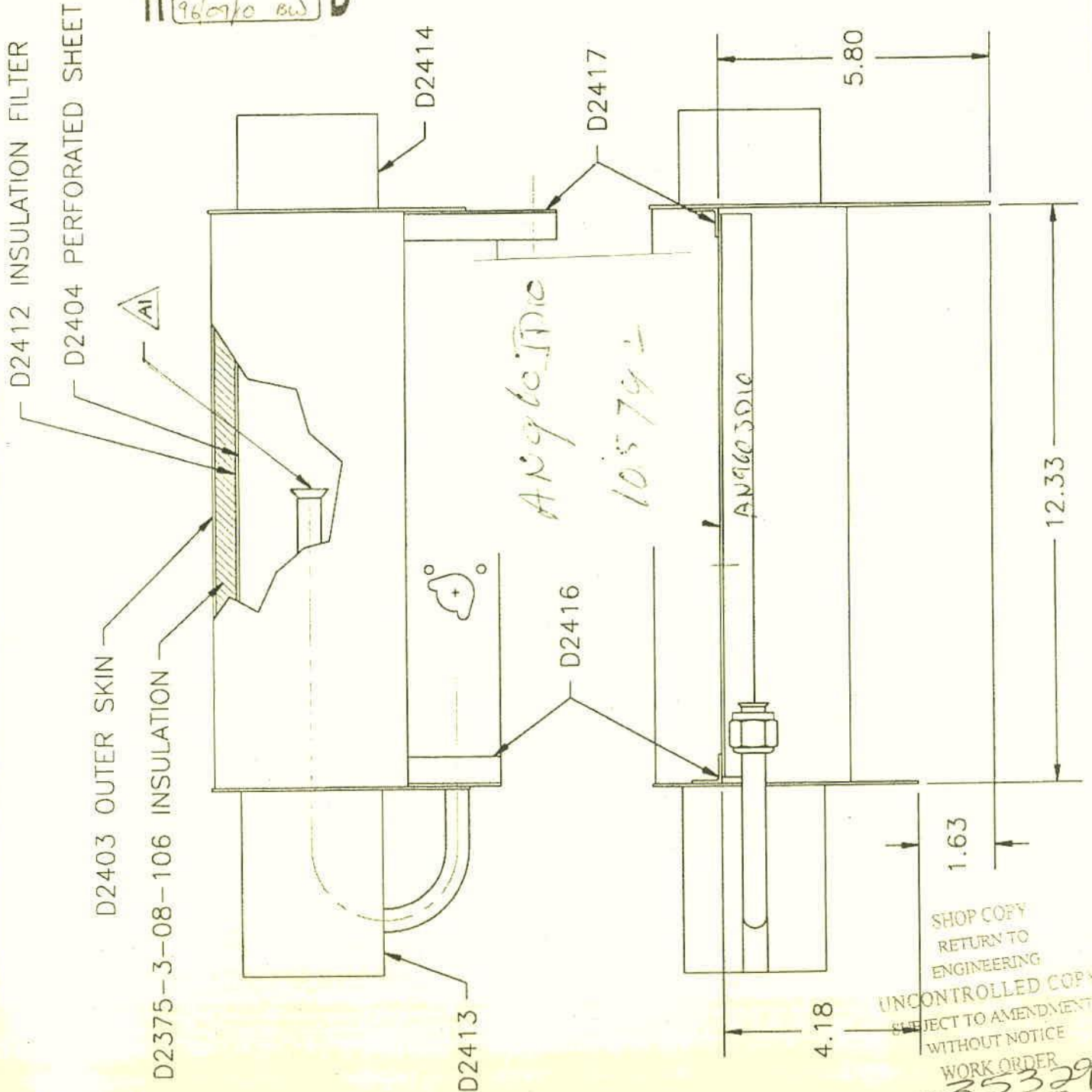
NOTE: Date & initial all entries



DART

PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2410	REV. A SHEET 2 OF 2
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY	SCALE

RELEASED
960910 BW



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WORK ORDER
NO. 35329

